

This Page Is Inserted by IFW Operations  
and is not a part of the Official Record

## **BEST AVAILABLE IMAGES**

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

**IMAGES ARE BEST AVAILABLE COPY.**

**As rescanning documents *will not* correct images,  
please do not report the images to the  
Image Problem Mailbox.**

12

# EUROPEAN PATENT APPLICATION

21 Application number: 79104419.1

22 Date of filing: 09.11.79

51 Int. Cl.<sup>3</sup>: **G 03 C 1/72**  
**C 07 F 7/08, C 07 F 15/00**

30 Priority: 01.12.78 US 965712

43 Date of publication of application:  
 11.06.80 Bulletin 80/12

84 Designated Contracting States:  
 DE FR GB

71 Applicant: **EASTMAN KODAK COMPANY**  
 343 State Street  
 Rochester, New York 14650(US)

72 Inventor: Gysling, Henry James  
 Kodak Park  
 Rochester New York(US)

74 Representative: Brandes, Jürgen, Dipl.-Chem. Dr. et al,  
 Thierschstrasse 8  
 D-8000 München 22(DE)

54 Photographic element having a Te (II) metal complex, Te (II) compounds and metal complexes thereof.

57 Photographic element containing a photosensitive metal  
 complex of a nonpolar, organic solvent-soluble tellurium  
 compound having the formula:



wherein:

n is an integer from 1 to 10 and

R, R' and R'' are alkyl, aryl or heterocyclic radicals. Transi-  
 tion metal complexes of these tellurium compounds can be  
 prepared from compounds of silver, copper, palladium, man-  
 ganese and cobalt.

EP 0 011 754 A2

Nov. 9, 1979

0011754

PHOTOGRAPHIC ELEMENT HAVING A Te (II) METAL  
COMPLEX, Te (II) COMPOUNDS AND METAL COMPLEXES THEREOF

The present invention relates to a photographic element comprising a photosensitive metal complex of a diorganotellurium(II) compound wherein the organo radical contains silicon. This invention also relates to diorganotellurium(II) compounds wherein the organo radical contains silicon and to photosensitive metal complexes thereof. These tellurium compounds and transition metal coordination complexes incorporating them as ligands are soluble in nonpolar organic solvents. This solubility property makes them particularly useful in various catalytic processes including catalytic imaging processes.

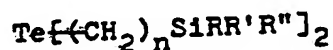
Diorganotellurium compounds are well-known in the art. Organic radicals which are bonded to a tellurium(II) or a tellurium(IV) atom can take a wide variety of forms. For example, diorganotellurium dihalides and dicarboxylates are known. (See K. J. Irgolic, The Organic Chemistry of Tellurium, Gordon and Breach Science, Publ., London, 1974.) These diorganotellurium compounds have been found to be useful as oxidants in tellurium physical development processes. Certain diorganotellurium compounds can function as ligands for transition metal compounds, such as  $\text{Cu}_2\text{Br}_2[\text{Te}(\text{C}_6\text{H}_5)_2]_4$  and  $\text{CuI}[\text{Te}(\text{p-MeC}_6\text{H}_4)_2]_2$ . These compounds have no significant nonpolar organic solvent solubility. This is unfortunate because solubility of these solvents would offer many advantages where the compounds are used as the oxidant in an image-forming combination or is part of the light-sensitive component in a photographic element.

Silicon-containing moieties can impart nonpolar organic solvent solubility to certain organometallic compounds. This is taught in U.S. Patent 3,763,197. Thus, compounds such as  $\text{Ti}[\text{CH}_2\text{Si}(\text{CH}_3)_3]_4$  and the like are known to have useful nonpolar organic solvent solubility. While it may appear desirable to form similar tellurium

-2-

compounds, difficulties would be encountered if this were attempted. Known organometallic compounds having these silicon-containing moieties are made using a conventional salt-elimination reaction, i.e., using a Grignard reagent. If a similar preparation were attempted with tellurium as the metal, only the tellurium(IV) compound would be produced, e.g.,  $\text{Te}[\text{CH}_2\text{Si}(\text{CH}_3)_3]_2\text{Cl}_2$ . There is no known method of making stable, nonpolar, organic solvent-soluble tellurium(II) compounds with these silicon-containing moieties.

The photographic element of the present invention comprises transition metal complexes of diorganotellurium(II) compounds which compounds have high solubility in nonpolar organic solvents, are stable and have the formula:

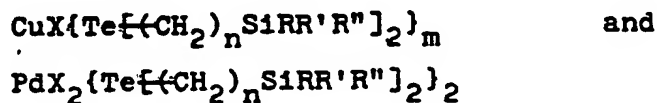


wherein:

n is an integer from 1 to 10 and

R, R' and R'' are alkyl, aryl or heterocyclic radicals.

Not only do the compounds described above have high solubility in nonpolar organic solvents, but light-sensitive transition metal complexes of these compounds retain this solubility. Useful complexes can be made, for example, from silver, copper, palladium, manganese and cobalt. Particularly useful complexes are those having the general formulae:



wherein:

X is a halogen or a pseudohalogen,

m is an integer from 1 to 3 and

n, R, R' and R'' are as described above.

The tellurium(II) compounds of the present invention can be used as the source of tellurium in a physical development process. Thus, in another aspect of the present invention there is provided an image-forming combination comprising (i) the described tellurium(II) compounds and (ii) a reducing agent. The image-forming combination can be coated, either with or without a binder, on a suitable support to form a useful amplification element. The image-forming combination can also be in a solution which is useful as a tellurium physical development bath.

The compounds described above are liquids which can be converted to solids by oxidation with halogens to yield the tellurium(IV) derivative, for example,  $I_2Te-[CH_2Si(CH_3)_3]_2$ . The described tellurium(IV) solids are also highly soluble in nonpolar organic solvents. Thus, the silicon-containing moieties impart the desired solubility to the tellurium compound or complex of which it is a part. As a result, the present invention provides a ready source of soluble transition metal catalyst. Further, for the first time it is possible to coat transition metal complexes, such as copper and palladium light-sensitive complexes, from inexpensive and readily available nonpolar solvents.

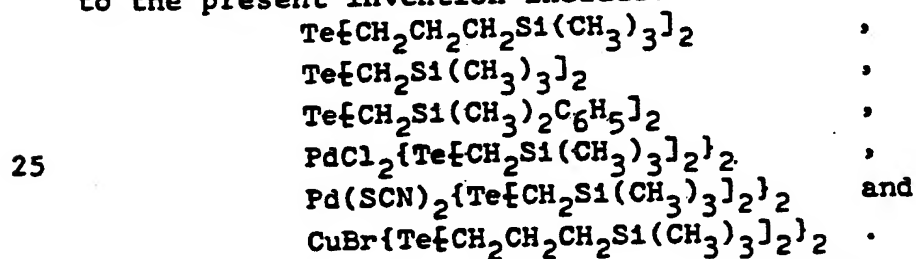
The new tellurium(II) compounds (1) and the preferred complexes (2) and (3) are represented by the formulae:

- (1)  $Te\{-(CH_2)_nSiRR'R''\}_2$ ,
- (2)  $CuX\{Te\{-(CH_2)_nSiRR'R''\}_2\}_m$  and
- (3)  $PdX_2\{Te\{-(CH_2)_nSiRR'R''\}_2\}_2$ .

The integer n can be from 1 to 10, and the integer m is from 1 to 3. While alkylene chains longer than 10 carbon atoms are useful for some purposes, compounds having shorter alkylene chains tend to be more soluble in nonpolar organic solvents. Thus, a lower alkylene, i.e., when n is from 1 to 4, is preferred, particularly when n

is equal to 1. Similarly, while R, R' and R'' can be either alkyl having 1 to 10 carbon atoms, preferably 1 to 4 carbon atoms, or aryl such as phenyl including substituted aryl or multiple ring aromatic groups such as naphthyl, smaller groups such as phenyl are preferred because they tend to increase solubility. R, R' and R'' can also be heterocyclic groups. Useful heterocyclic radicals include thiazoles, isoxazoles, benzothiazoles, benzoxazoles and phenyloxazoles. Again, smaller groups are preferred. At least two of R, R' and R'' are preferably lower alkyl, particularly methyl. The anion X in the copper and palladium complexes described above can be halogen such as chlorine, bromine and iodine or a pseudohalogen. Pseudohalogens are anions which have properties very similar to halogens such as  $\text{SCN}^-$ ,  $\text{NCO}^-$ ,  $\text{NCSe}^-$  and  $\text{NCTe}^-$ . In the copper complexes, m can be an integer from 1 to 3. The exact value of m depends on the coordination number assumed by the copper atom of the complex.

Illustrative compounds and complexes according to the present invention include:



The described diorganotellurium(II) compounds and their transition metal complexes are soluble in non-polar organic solvents. By "soluble" is meant that it is possible to form at least a 0.1 M solution of the tellurium(II) compound or complex in the selected solvent at room temperature. Typically, however, the preferred compounds are more soluble and 1.0 M solutions of the compounds are possible in nonpolar organic solvents at room temperature. Typical nonpolar organic solvents include ethers such as dimethyl ether and diethyl ether;

saturated hydrocarbons including hexane and cyclohexane; and halocarbon solvents such as carbon tetrachloride, chloroform, chlorobenzene and trichloroethylene.

The new diorganotellurium(II) compounds of the present invention can be prepared by a two-step reaction sequence. In the first step, elemental tellurium is reduced to tellurium (2-). This can be accomplished, for example, by reacting tellurium metal with a reducing agent such as potassium borohydride in an aqueous solution of sodium hydroxide. In the second step, the tellurium (2-) is reacted with two equivalents of the appropriate silicon-containing alkyl halide in an alcohol solution. Because the tellurium (2-) is extremely air-sensitive, these steps should be carried out in an inert atmosphere such as nitrogen or argon. After refluxing the tellurium (2-) and silicon-containing alkyl halide solution for a time sufficient to complete the reaction, typically 3-20 hours, the alcohol is distilled from the solution. The diorganotellurium(II) is then extracted from the aqueous solution with a suitable solvent such as diethyl ether. The resulting diorganotellurium(II) compound is a liquid at room temperature. It can be purified by conventional methods such as by vacuum distillation. Alkyl halides containing the necessary tertiary silicon atom are known in the art. Examples of useful silicon-containing alkyl halides include  $(\text{CH}_3)_3\text{SiCH}_2\text{CH}_2\text{CH}_2\text{Cl}$ ,  $\text{C}_6\text{H}_5(\text{CH}_3)_2\text{SiCH}_2\text{Cl}$ ,  $[(\text{CH}_3)_3\text{Si}]_2\text{CH}_2\text{Cl}$  and  $(\text{C}_2\text{H}_5)_3\text{SiCH}_2\text{Cl}$ .

The transition metal complexes of the diorganotellurium(II) compounds of the present invention can be prepared by known methods. Useful methods are described in U.S. Patent 3,859,092 and by M. R. Collier et al, J. Chem. Soc. (Dalton), 445 (1973). For example, copper(I) diorganotellurium(II) complexes can be prepared by reacting the proper copper(I) halide with a diorganotellurium(II) compound of the invention in aqueous ethanol which contains the appropriate hydrohalic acid.

Palladium complexes of the diorganotellurium(II) compounds of the present invention are conveniently prepared by a substitution reaction by using the appropriate palladium complex which is coordinated to labile ligands.

- 5 Useful palladium complexes for this substitution reaction include  $K_2Pd(SCN)_4$ ,  $K_2PdCl_4$ ,  $K_2Pd(C_2O_4)_2$  and  $PdCl_2 \cdot (NCC_6H_5)_2$ .

One embodiment of the present invention is an image-forming combination comprising (i) the described  
10 tellurium(II) compound or complex as an oxidizing agent and (ii) a reducing agent. The image-forming combination can be in a solvent thereby forming a physical developer solution. Alternatively, the image-forming combination can be on a suitable support either alone or  
15 with other components, including light-sensitive compounds, other oxidants or binders. Because of the desirable solubility properties of the compounds and complexes of this invention the image-forming combination of the present invention can be used with, and coated from, nonpolar organic solvents. Suitable solvents  
20 of this type are described above in relation to the solubility of the present compounds.

The complexes can be used individually or mixtures of two or more of the complexes can be used. A  
25 photosensitive element can be prepared by soaking porous paper in a solution containing a transition metal complex of a diorganotellurium(II) compound of the present invention. The paper is then dried, thereby producing a photosensitive element. If desired, the complex can be  
30 added to a binder solution and coated onto a substrate.

The binder used as a vehicle for the photosensitive complex can be any of the hydrophilic binders used in photographic elements. Because the complexes are soluble in nonpolar organic solvents, polymers which are  
35 soluble in these solvents can be used as binders. It is not to be understood that, although many binders may be used herein, the binder should be permeable to the developer used if



a solution is used to process the element. The binder should not absorb appreciably in the region of sensitivity of the complex. The complex may be used with varying amounts of binder material. Preferably, the complex-to-binder weight ratio is from about 3:1 to about 1:2.

The elements having the described complexes thereon are typically exposed through a pattern of actinic radiation to provide a latent image corresponding to the exposed areas. The transition metal complexes of the present invention are sensitive to actinic radiation such as ultraviolet rays generally in the wavelength range of 1800 to 4000 Angstroms. Many sources of ultraviolet light may be used such as high-pressure mercury vapor lamps, carbon arc lamps, and the like. Some of these complexes are also sensitive to electron-beam exposure, as well as exposure to neutrons and  $\alpha$ -particles. As used herein, "electromagnetic radiation" is intended to include all of these forms of energy.

In some instances, the rate of development of the described photosensitive element can be considerably accelerated by heating the exposed elements prior to treatment with a physical developer. Thus, a shorter exposure time to achieve a developable image can be used if the element is heated after exposure and prior to development. In some cases, exposed photosensitive complexes of the present invention will "print out" by the application of heat after imagewise exposure. Generally, the element can be heated to about 100° C to about 200° C for about 1 to about 60 seconds to exhibit these effects.

After imagewise exposure, an element having a layer containing a complex of the present invention has an imagewise distribution of catalytic transition metal nuclei. By "nuclei" is meant small catalytic specks of elemental metal. This imagewise distribution can be physically developed by contacting the layer with a redox image-forming combination using any of a wide variety of methods. A particularly suitable method is simply to

immerse the element into a physical developer bath. Alternatively, the layer containing the catalytic transition metal nuclei can be overcoated with a viscous physical developer solution. In still another method, the catalyst layer can be contacted with a dry amplification element containing a suitable physical developer composition.

A typical physical developer composition contains the salt of a heavy metal ion, a complexing agent for the ion and a reducing agent for the ion. Useful heavy metal salts include silver salts, cupric salts, palladium salts, tellurium salts (including the compounds of the present invention) and nickel salts. The physical developer can also contain a variety of other materials. Useful additives include acids and bases to adjust pH, buffers, preservatives, thickening agents, brighteners, surfactants and the like.

Another type of physical developer produces a dye image. These developers typically contain a reducible dye precursor and a reducing agent. Physically developable catalysts having deposits of a phthalocyanine or a formazan dye are autocatalytic.

The heat-activatable physical developer compositions can comprise a source of silver ion, which is believed to be an oxidizing agent which reacts with a reducing agent, the reaction being catalyzed by the physically developable nuclei. The oxidizing agent, which is preferably a silver salt, should be resistant to darkening under illumination to prevent undesired deterioration of a developed image. Preferably, the silver salt oxidizing agent is a long-chain fatty acid. As employed herein, "long-chain" is intended to mean a chain of carbon atoms containing at least 10 carbon atoms, typically 10-30 carbon atoms. An especially useful class of silver salt oxidizing agents is the silver salt of

long-chain fatty acids containing at least 20 carbon atoms. Compounds which are useful silver salts of long-chain fatty acids are, for example, silver behenate, silver stearate, silver oleate, silver laurate, silver hydroxystearate, silver caprate, silver myristate and silver palmitate.

Other silver salt oxidizing agents which are useful in the present invention include silver benzoate, silver phthalate, silver acetate, silver acid phthalate and the like; silver phthalazinone and silver benzotriazole, silver saccharin.

A particularly useful source of silver ion is a dispersion of the silver complex of the ligand 3-carboxymethyl-4-methyl-4-thiazoline-2-thione. The dispersion of this complex with a reducing agent to form a heat-activatable physical developer composition is described in U.S. Patent 3,785,850.

The following examples are presented to illustrate the invention and not to limit it in any way.

**Example 1: Synthesis of  $\text{Te}[\text{CH}_2\text{CH}_2\text{CH}_2\text{Si}(\text{CH}_3)_3]_2$**

Potassium borohydride (44.7 g, 0.828 mole) was added to 700 ml of a 20% aqueous sodium hydroxide solution in a 2-liter, 3-neck flask fitted with a reflux condenser, dropping funnel and argon-gas inlet tube. The solution was deaerated with argon and then tellurium metal (42.2 g, .331 g-atom; Alfa Products Tellurium shot) was added. The resulting suspension was refluxed under argon for 2.5 hr to give a clear yellow solution. To this solution of  $\text{Te}^{2-}$  was added a deaerated solution of  $(\text{CH}_3)_3\text{SiCH}_2\text{CH}_2\text{CH}_2\text{Cl}$  (100 g, 0.662 mole) in 800 ml of methanol. The reaction solution was refluxed 20 hr and thereafter the methanol was removed by distillation. The residual solution was then extracted with two 1-liter diethyl ether portions. The combined ether extracts were washed with water, dried over magnesium sulfate and the ether distilled off to give a pale orange liquid (113 g, 95.6%). The crude telluride was purified by vacuum distillation.

001175.

-10-

The titl compound was confirmed by elemental analysis. Elemental analysis, boiling point and index of refraction for the title compound and other compounds prepared in an analogous manner are presented in Table 1.

Example 4: Synthesis of  $\text{CuBr}\{\text{Te}\{\text{CH}_2\text{CH}_2\text{CH}_2\text{Si}(\text{CH}_3)_3\}_2\}_2$ 

To a solution of 11.5 g (32 moles)  $\text{Te}\{\text{CH}_2\text{CH}_2\text{CH}_2\text{Si}(\text{CH}_3)_3\}_2$ , prepared as described in Example 1, in 500 ml trichloromethane were added 2.25 g (15.7 mmoles) of solid CuBr (prepared as described in Inorg. Synth., 2, p. 3 (1946)). The reaction solution was stirred at room temperature for 10 hr and then the solvent was removed under vacuum to give a white residue. The residue was washed with 100 ml methanol at room temperature and then recrystallized from 500 ml hot methanol to give 5 g of pure product as white needles. The title complex was confirmed by elemental analysis. The melting point was 55° C.

Example 5: Photosensitivity of  $\text{PdCl}_2\{\text{Te}\{\text{CH}_2\text{CH}_2\text{CH}_2\text{Si}(\text{CH}_3)_3\}_2\}_2$ 

A solution of 100 mg of  $\text{PdCl}_2\{\text{Te}\{\text{CH}_2\text{CH}_2\text{CH}_2\text{Si}(\text{CH}_3)_3\}_2\}_2$  (prepared as described in Example 2-B) in 10 ml dichloromethane was imbibed in paper stock and imagewise-exposed for 60 sec under a high-pressure mercury arc. Immersion of this exposed paper in an aqueous dye physical developer (5% in triphenyltetrazolium chloride and 1% in hydrazine) gave a red negative image of the corresponding formazan dye.

Example 6: Photothermographic property of  $\text{CuBr}\{\text{Te}\{\text{CH}_2\text{CH}_2\text{CH}_2\text{Si}(\text{CH}_3)_3\}_2\}_2$ 

A solution containing 100 mg of the title complex (prepared as described in Example 4) dissolved in 10 ml of dichloromethane was imbibed into paper stock. A 30-sec imagewise exposure of this sensitized paper stock under a 360-watt high-pressure mercury arc resulted in a faint yellow printout. Subsequent heating of the exposed paper for 10 sec at 175° C produced a grey-black negative image.

Example 7: The use of  $\text{CuBr}\{\text{Te}\{\text{CH}_2\text{CH}_2\text{CH}_2\text{Si}(\text{CH}_3)_3\}_2\}_2$  as an oxidant in dry physical development

A dry element was prepared by dissolving 100 mg of  $\text{CuBr}\{\text{Te}\{\text{CH}_2\text{CH}_2\text{CH}_2\text{Si}(\text{CH}_3)_3\}_2\}_2$  (as an oxidant) and 120 mg of 2,6-dichloro-4-benzenesulfonamidophenol (as a reducing agent) in 10 ml of a 7% solution of poly(vinyl

-14-

butyral) in a 1:1 solution of acetone and toluene. The resulting image-forming combination was coated at 10 mils wet thickness onto a subbed poly(ethylene terephthalate) support to form an amplification element. This  
5 element was laminated to a second piece of poly(ethylene terephthalate) on which a step tablet distribution of nuclei of palladium had been vacuum-evaporated so that the image-forming combination was in contact with the palladium. Passing of the laminate through heated  
10 rollers at 175° C resulted in selective copper amplification of the palladium nuclei down to a coverage of  $3.94 \times 10^{-14}$  atoms/cm<sup>2</sup>.

## Claims:

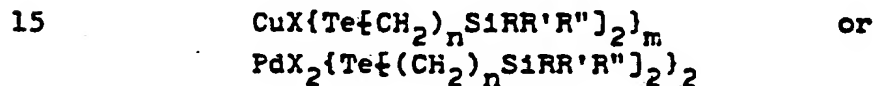
1. A photographic element comprising a support having hereon a layer comprising a photosensitive metal complex characterized in that said complex  
 5 is a transition metal complex of a tellurium(II) compound having the formula:



wherein:

- 10            n is an integer from 1 to 10 and  
              R, R' and R'' are alkyl, aryl or heterocyclic groups.

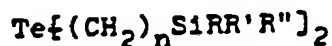
2. A photographic element according to Claim 1 characterized in that said complex has the formula:



wherein:

- X is a halogen or a pseudohalogen and  
              m is an integer from 1 to 3.
- 20            3. A photographic element according to Claims 1 or 2 characterized in that n is an integer from 1 to 4.
4. A photographic element according to Claims 1, 2 or 3 characterized in that at least two of  
 25            said R, R' and R'' groups are lower alkyl, preferably methyl.

5. A tellurium(II) compound having the formula:

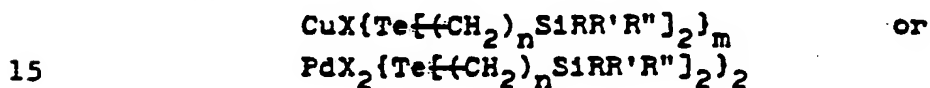


wherein:

5            n is an integer from 1 to 10 and  
R, R' and R'' are alkyl, aryl or heterocyclic groups.

6. A tellurium(II) compound according to Claim 5 characterized in that n is an integer from 1 to 4 and at least two of R, R' and R'' are lower alkyl groups, preferably methyl.

7. A transition metal complex having the formula:



wherein:

X is a halogen or a pseudohalogen;  
m is an integer from 1 to 3;  
n is an integer from 1 to 10; and R, R' and R'' are alkyl, aryl or heterocyclic groups.

8. A complex according to Claim 7 characterized in that n is an integer from 1 to 4 and at least two of R, R' and R'' groups are lower alkyl, preferably methyl.